

Work Order ID 154819

Thursday, December 22, 2016 7:16:55 AM

154819

Page 1

Item ID: D2666-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH, Fwd, Aft, In
 Start Date: 1/3/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/10/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: DEC 22 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2666	Rev D								

100		0.01							DAS 44 9-89 17-02-07
100	HAAS CNC VERTICAL MACHINING #1					4	Ø		
HAAS 1	Memo	0.25							
HAAS CNC vertical machine #1	Program batch number.1-Inspect part number and batch number are programmed correctly.4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6								
110		0.00							DAS 44 9-89 17-02-07
110	CONVENTIONAL MILLING MACHINE					4	Ø		
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120		0.00							DAS 44 9-89 17-02-07
120	QC2- Inspect parts off machine FAI/FAIB					4	Ø		
QC	Memo	0.00							
Quality Control									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 154819

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Page 2

Thursday, December 22, 2016 7:16:55 AM

Item ID: D2666-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH, Fwd, Aft, In
 Start Date: 1/3/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/10/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				4	0		DAS 20 9-89 17-02-08
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.07				(X4)	0		2017/02/09 BER
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m 136657</i> Memo START TIME: <u>1:40</u> FINISH TIME: <u>2:10</u> OVEN TEMPERATURE:	0.00 0.02				4	0	170215	DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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154819

Thursday, December 22, 2016 7:16:55 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/3/2017 **Start Qty:** 2.00

?

Customer:

Required Date: 1/10/2017 **Req'd Qty:** 2.00

2

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

DAS
38
9-38
FEB 16 201

170

Identify as per dwg & Stock Location: 4462

0.00

170

Packaging

Memo

0.00

Packaging

4 FEB 24 2017

180

QC21- Final Inspection - Work Order Release

0.02

180

QC

Memo

0.03

Quality Control

DAS
21
9-89

FEB 24 2017

DAS
21
9-89

FEB 24 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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☐ OTHER : _____					

Picklist Print

Thursday, December 22, 2016 7:16:55 AM

Page 1

Work Order ID: 154819

154819

Parent Item: D2666-2

D2666-2

Parent Item Name: Saddle, RH, Fwd, Aft, In

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	29.0000	1	2			
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D6101-001

Saddle Billet

DAS
44
9-89

17-02-07

Location

Loc Qty

Loc Code

MAT042

29

150689

9

151620

20

1
3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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		OTHER : ☐																																																									

DART AEROSPACE LTD		Work Order:	154819
Description: 206 Saddle, Inboard, Right side		Part Number:	D2666-2
Inspection Dwg: D2666 Rev: D DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.121	.121	.121	
B	0.100	0.140		.120	.119	.118	.118	
C	2.470	2.510		2.491	2.492	2.492	2.492	
D	0.100	0.180		.130	.130	.130	.130	
E	0.210	0.230		.224	.224	.224	.225	
F	1.313	1.343		1.328	1.329	1.329	1.329	
G	0.240	0.260		.255	.256	.255	.255	
H	0.615	0.685		.655	.655	.655	.655	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.000	1.000	1.000	1.000	
K	0.235	0.240		.238	.238	.238	.238	
L	0.510	0.515		.512	.512	.512	.512	
M	0.100	0.120		.113	.113	.113	.113	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		5.996	5.996	5.997	5.998	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.497	.498	.497	.498	
S	0.312	0.318		.314	.314	.314	.314	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.548	.550	.550	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.258	.258	.258	.258	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								

DAS Accept/Reject

Measured by:	44	Date:	17-02-07
Audited by:	20	Date:	17-02-08
Prototype Approval:	9-89	Date:	

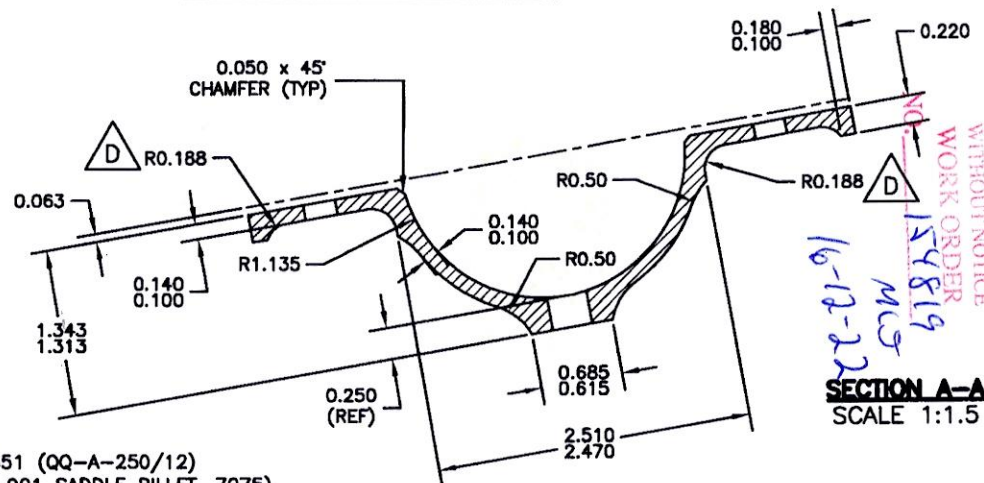
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	

DART

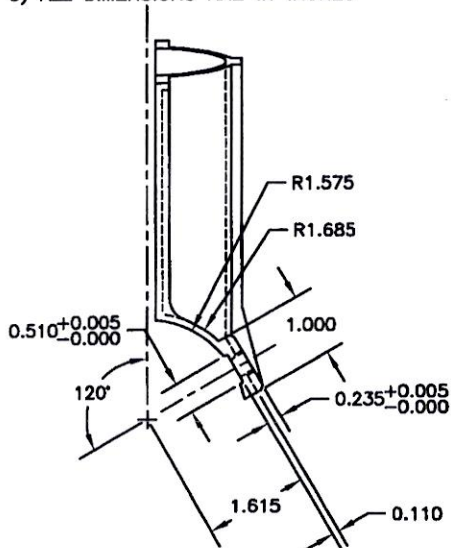
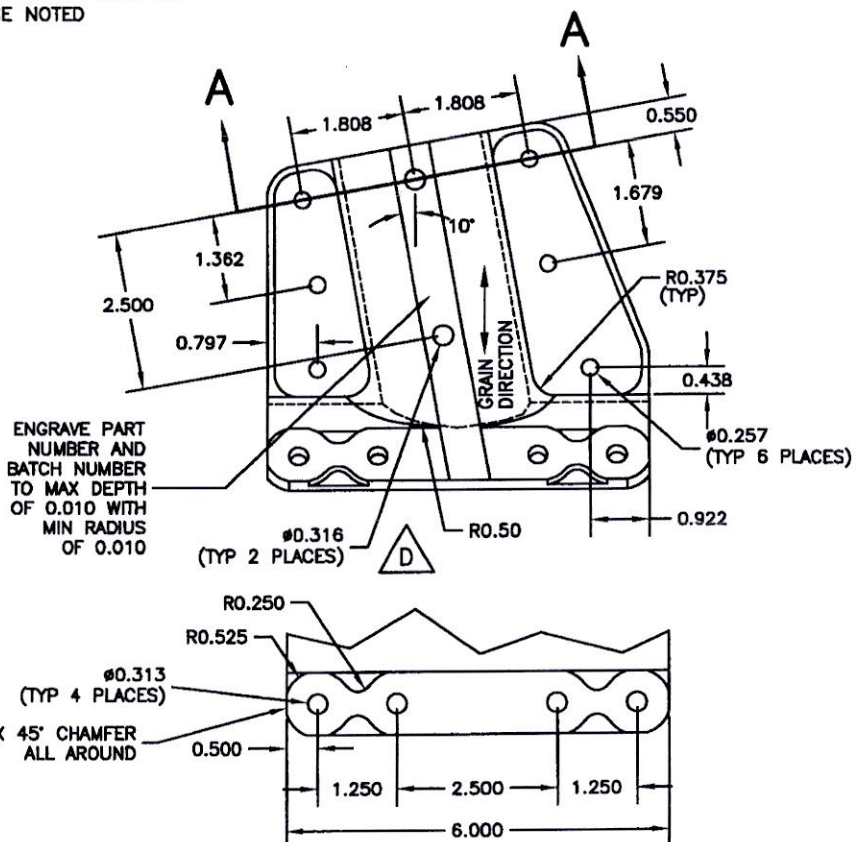
RELEASED

07-02-12

DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D2666
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$		

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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